

Date: Wednesday, 2/15/2006 9:16:18 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PATIENT STOP ASSEMBLY
Job Number : 25266	
Estimate Number : 10949	
P.O. Number : NIA	Part Number : D2493
This Issue : 2/15/2006 S.O. No. : NIA	Drawing Number : D2493 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/15/2005 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : NIA	Material : NIA
Written By : SEE COMMENT BELOW	Due Date : 1/10/2006
Checked & Approved By : SEE ABOVE USER	Qty: 19 Um: Each
Comment : Est. C 03.01.17 Reformat; Incorporated D2492 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 1.9140 sf(s)/Unit Total : 36.3669 sf(s)
 5052-H32 .080 Sheet
 Material: 5052-H32 (QQ-A-250/8) 0.080" thick
 (M5052H32S.080)
 Batch _____

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Shear blanks: 8.000" x 25.942"
 Machine per Folio FA041 and Dwg D2492
 Identify as D2492

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr
 Form using Jig DT2482B

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 9:16:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Part Number: D2493

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

D2444

Pip Pin Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 38.0000 Each(s)

Pip Pin Assembly

Pick:

Qty Part Number

Description

Batch

2 D2444

Pip Pin

5 B 25272
2 B 25276

11 B 25811

8.0

D2492

Patient Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 19.0000 Each(s)

Patient Stop

Pick:

Qty Part Number

Description

Batch

1 D2492

Patient Stop

B 25271

9.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 38.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 AN960JD10

Washer

M 19413

10.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 38.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

2 MS21042L3

Nut

M 18180

11.0

MS27039107

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 38.0000 Each(s)

Screw

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-07

Screw

(2) M 11660
B 118057

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 06/21/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 9:16:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Part Number: D2493

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2493. D2492 on BOM as material listed in Step 2.

Identify as D2493

SIS 06/02/15 (9)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-15 7

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57179

6/2/17 (9)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/02/20 (9)

06/02/20

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

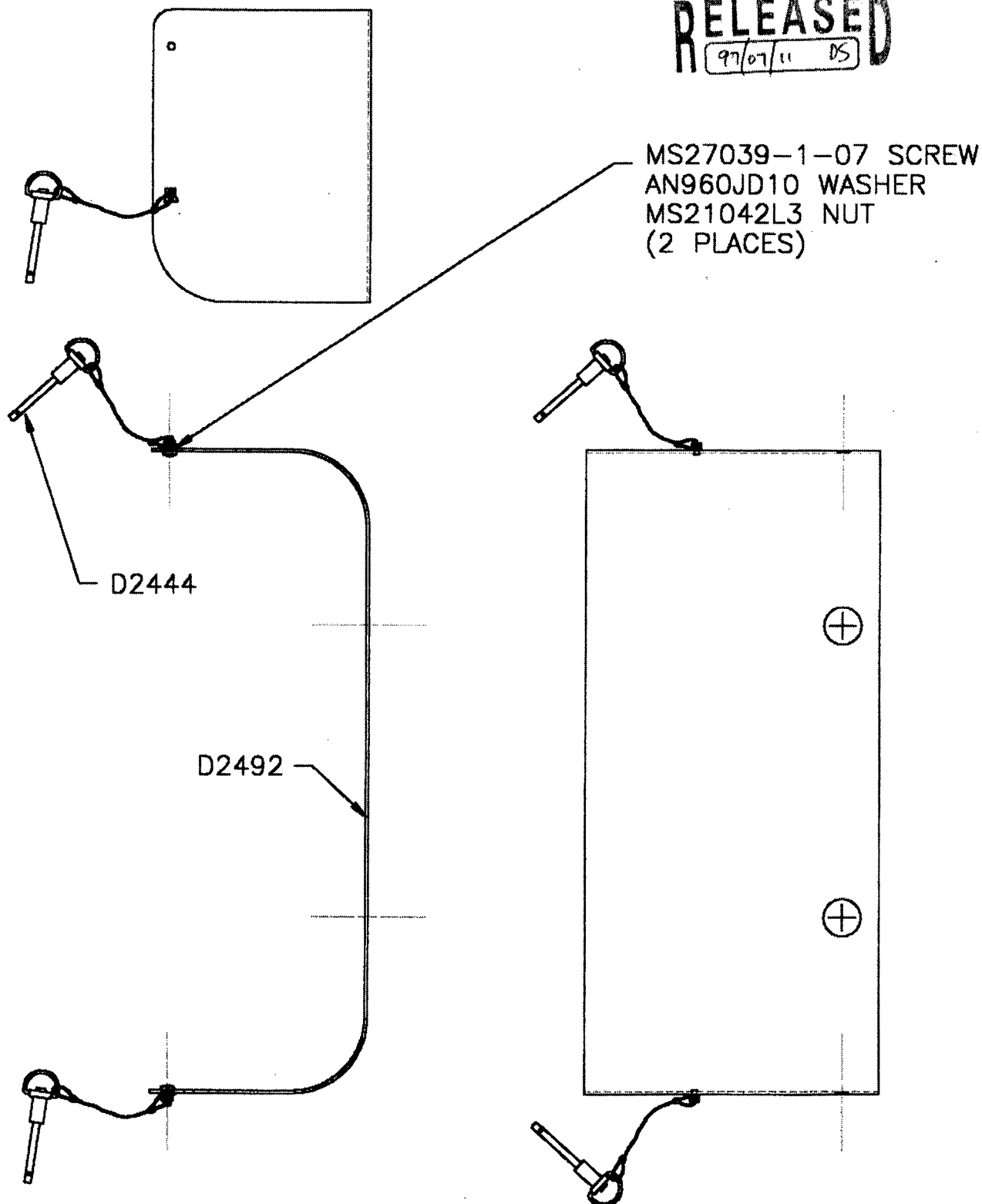
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>bw</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2493	REV. A SHEET 1 OF 1
DATE 95:24:10		TITLE PATIENT STOP ASSEMBLY	SCALE 1:4

RELEASED
97/07/11 DS



Date: Thursday, 12/15/2005 3:57:18 PM
 User: Kim Johnston

Process Sheet

Customer :	CW-DAR001 Dart Helicopters Services	Drawing Name :	PATIENT STOP ASSEMBLY	
Job Number :	25266	Part Number :	D2493	
Estimate Number :	10949	Drawing Number :	D2493 REV A	
P.O. Number :		Project Number :	N/A	
This Issue :	12/15/2005	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	A	
First Issue :	/ /	Material :		
Previous Run :		Due Date :	1/10/2006	Qty: 2 Um: Each
Written By :				
Checked & Approved By :				
Comment :	Est. C 03.01.17 Reformat; Incorporated D2492 KJ/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 1.9140 sf(s)/Unit Total : 3.8281 sf(s)
 5052-H32 .080 Sheet
 Material: 5052-H32 (QQ-A-250/8) 0.080" thick
 (M5052H32S.080)
 Batch M19052

SAD 02/21/05 2

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Shear blanks: 8.000" x 25.942
 Machine per Folio FA041 and Dwg D2492
 Identify as D2492

SAD 12/21/05 3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr
 Form using Jig DT2492B

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/15/2005 3:57:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Part Number: D2493

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

D2444

Pip Pin Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pip Pin Assembly

Pick:

Qty	Part Number	Description	Batch
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2	D2444	Pip Pin	
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8.0

D2492

Patient Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Patient Stop

Pick:

Qty	Part Number	Description	Batch
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1	D2492	Patient Stop	
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9.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	AN960JD10	Washer	
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10.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
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2	MS21042L3	Nut	
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11.0

MS27039107

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	MS27039-1-07	Screw	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/15/2005 3:57:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Part Number: D2493

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2493. D2492 on BOM as material listed in Step 2.

Identify as D2493

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>bw</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2493	REV. A SHEET 1 OF 1
DATE 95:24:10	TITLE PATIENT STOP ASSEMBLY		SCALE 1:4

RELEASED
97/07/11 DS

MS27039-1-07 SCREW
AN960JD10 WASHER
MS21042L3 NUT
(2 PLACES)

